

Date: Thursday, 12/13/2007 11:14:57 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: VALVE ASSEMBLY (1/2")			
Job Number	: 36284						
Estimate Number	: 10727						
P.O. Number	: N/A		Part Number	: D200108			
This Issue	: 12/13/2007	S.O. No.	: N/A		Drawing Number	: D2001 REV C	
Prsht Rev.	: NC		Project Number	: N/A			
First Issue	: N/A		Drawing Revision	: C			
Previous Run	: 34274		Material	: N/A			
Written By			Due Date	: 12/19/2007			
Checked & Approved By			Qty:	10	Um: Each		
Comment	: Est. C 03.04.11 Reformat KJ/RF						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
Comment: PURCHASING Issue P/O: <u>5279</u> <u>C07112113</u> Order Apollo 76-10301 valve Ø0.5" Possible Supplier: Flow Control Material release note is required		
2.0	7610301	VALVE
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) VALVE		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached		
4.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D2001 Discard handle, retain nut		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Remove existing ID numbers on valve and replace with Dart part number and batch number		
5.1 machine part. that will collect P.R. per ATTACHED DWG.		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/01/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 11:14:57 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VALVE ASSEMBLY (1/2")

Job Number: 36284

Part Number: D200108

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



10/10



10/10/15 x10

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST2

10/10/15 x10

8.0 QC21

FINAL INSPECTION/W/O RELEASE



10

Comment: FINAL INSPECTION/W/O RELEASE

10/10/15 x10

Job Completion



10/10/15 x10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

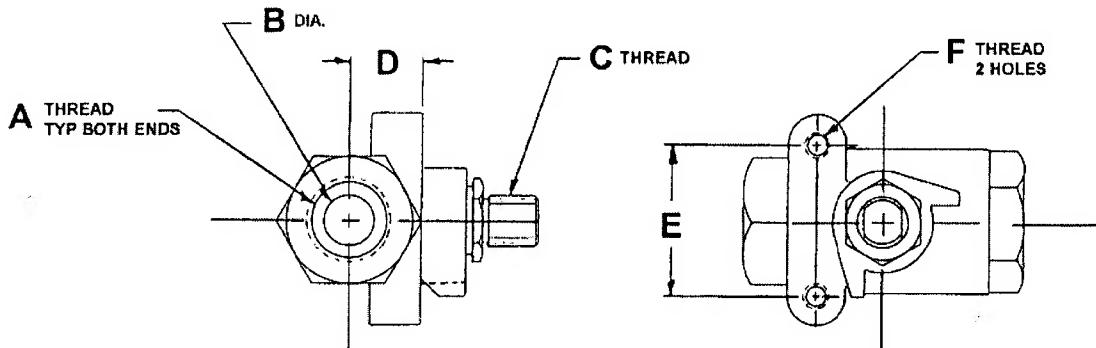
NOTE: Date & initial all entries

DARTDRAFT COPY IS
FOR INFORMATION
ONLY

DESIGN R2	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2001	REV. C SHEET 1 OF 1
DATE 04.07.06		TITLE VALVE ASSEMBLY	SCALE NTS
—	90.04.02	NEW ISSUE	
A	92.05.12	-043 ADDED	
B	96.04.10	DART P/N CHG,041-6,042-12,ADD -16	
C	04.07.06	ADD D2001-4	

RELEASED
04.04.04

SPECIFICATION CONTROL DRAWING



Dart P/N	Apollo P/N	A	B	C	D	E	F
D2001-4	76-101-32	1/4 NPT	0.370	3/8-24 NF	0.56	1.120	10-24 UNC
D2001-6	76-102-01	3/8 NPT	0.370	3/8-24 NF	0.56	1.120	10-24 UNC
D2001-8	76-103-01	1/2 NPT	0.500	3/8-24 NF	0.60	1.120	10-24 UNC
D2001-12	76-104-01	3/4 NPT	0.680	7/16-20 NF	0.79	1.370	10-24 UNC
D2001-16	76-105-01	1 NPT	0.870	7/16-20	0.99	1.370	10-24 UNC

NOTES:

- 1) POSSIBLE SUPPLIER: FLO-CONTROL INC. OR APOLLO VALVE DIVISION
- 2) DISCARD HANDLE AND ATTACHING NUT, EXCEPT FOR D2001-4
- 3) CHECK DIMENSION SHOWN ON THIS DRAWING
- 4) REFERENCE INFORMATION:

MATERIAL: 316 STAINLESS STEEL
 INVESTMENT CAST COMPONENTS
 MEETS NACE-MR-01-75
 MEETS WW-V-35C TYPE II, COMP SS, STYLE 3
 PRESSURE RATING: 2000 PSI @ 100°F
 150 PSI @ 400°F

- 5) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. *30284*

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ACI-028229830036447

ECI

Commercial Invoice

Invoice Number	Purpose of Shipment	Curr	Ult Dest.
Export Dt	C.I. References	USD	CA
12/19/2007	500511905	Pkgs	Bill T/C
		1	1517-9324-0
		BOX	

Shipper: Debbie Sims
 Conbraco Industries
 1418 S Pearl St
 Pageland
 SC 29728 US (843) 672-6161
 ID/EIN: 561345109

Consignee: DART AEROSPACE
 MAIN FINISHED GOODS LOC
 1270 ABERDEEN ST
 HAWKSBURY
 ON K6A1K7 CA (770) 382-0006
 ID/EIN: 8

Broker Importer

DART AEROSPACE
 MAIN FINISHED GOODS LOC
 1270 ABERDEEN ST
 HAWKSBURY
 ON K6A1K7 CA (770) 382-0006
 ID/EIN:

Non-Resident Importer: N

Part Nbr:	Marks/Nbrs :	Cntry MFG: US	Net Wgt:	0.0	lbs
HS Code:	Unit Qty: 10.00 EA	Unit Value: 28.210000	Commodity Value:	282.10	
Desc: Stainless Steel Ball Valves					

Total Shipment Weight: 0.0	Total Commodity Value: 282.10
These commodities, technology, or software were exported from the United States in accordance with the Export Administration Regulations. Diversion contrary to United States law is prohibited.	Terms of Sale: FCA/FOB
	Freight: 0.00
	Insurance: 0.00
	Other: 0.00
	Total Invoice Value: 282.10

Comments:
 1)
 2)
 3)

I declare all information in this invoice to be true and correct.
 Signature of Shipper: Debbie Sims Debbie Sims 12/19/2007

Tracking Numbers: 028229830036447



**Purchase Order**

Date Dec 13, 2007	Page 1
Purchase Order Number PO00005279	

FAXED
6/11/2007

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

Vendor Address:

Flo-Control Inc.
80 Center Rd.
Cartersville, GA 30121
Phone (770) 382-0006
Fax (770) 382-0161

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VU-FL0001	Dec 13, 2007	N30	Fedex	Dec 21, 2007

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
10.0000	7610301	VALVE Comments: APOLLO P/N; 76-10301 VALVE 00.5" AS PER DWG D2001 REV. C	12/21/2007	No	49.729711	Each	497.30

Comments:	Tax Summary:	Less: included tax	0.00
CERTIFICATE OF CONFORMITY REQ'D UPON DELIVERY			
		Subtotal	497.30
		Total tax	0.00
		Total purchase order in USD Dollars	497.30

Entered By: CL CLAVOIE

Approved By:

REFERENCE ONLY

FLO-CONTROL, INC.
80 CENTER RD
CARTERSVILLE, GA 30121

770-388-0006

INV DATE INV NO. Pg.
12/26/07 66312 1

TERMS: NET 30 DAY
DUE DATE: 01/25/08

RECEIVED DEC 28 2007

BILL TO:
DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY ONT, CA K6A1K7

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY ONT CANADA K6A 1K7

ORDER NO.	DATE	CUSTOMER NO.	SRP	P.O. NO.	SHIP		SHIP VIA
					DATE	VIA	
59393	12/13/07	204700	5	P000005279	12/19/07	FEDERAL EXPRESS	
QTY ORDERED	ITEM	ITEM NO.			UNIT	UNIT PRICE	
QTY SHIPPED	UNIT	QTY BACKORDER		ITEM DESCRIPTION	DISC %	EXTD PRICE	
10	EACH	76-103-01	0	1/2" SS VALVE THREADED W/ MOUNTING PADS	0.00	49.73	497.30

S

SALES AMOUNT:	497.30
MISC. AMOUNT:	0.00
FREIGHT AMOUNT:	0.00
TOTAL TAX AMOUNT:	0.00
NET ORDER AMOUNT:	497.30
CASH RECEIVED:	0.00
BALANCE DUE:	497.30

Marc Bellavance

From: Roberto Fuentes [rfuentes@dartaero.com]
Sent: January 9, 2008 11:23 AM
To: 'Marc Bellavance'
Cc: David Shepherd
Subject: RE: D2001

Hi Marc,

David and I found no problem with this modification manufacture need to do, but we suggest this modification need to reflect in the drawing as an option since this is inconsistent problem.

Roberto

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: Wednesday, January 09, 2008 7:28 AM
To: 'Roberto Fuentes'
Subject: RE: D2001

See pictures attached.

Thanks!

Marc Bellavance
Mechanical Designer/Technical Support

DART aerospace Ltd.

Tel: 613-632-5200 Ext. 240
Fax: 613-632-9311
E-mail: mbellavance@dartaero.com
Web: www.dartaero.com

From: Roberto Fuentes [mailto:rfuentes@dartaero.com]
Sent: January 8, 2008 5:13 PM
To: 'Marc Bellavance'
Subject: RE: D2001

Hi Marc,

I got both e-mail. Send me the picture of the interference when you have a chance.

Roberto

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: Tuesday, January 08, 2008 12:45 PM
To: 'Fuentes, Roberto'
Subject: FW: D2001
Importance: High

Roberto,

I don't know if you had a chance to reply to the e-mail below.

I just found out (thanks to David) that when George changed my computer, my e-mail address was not setup properly (mbellanance@dartaero.com in stead of mbellavance@dartaero.com). Can you please resend your response at the correct e-mail address by replying to this e-mail?

Thanks and sorry for the inconvenience.

Marc Bellavance
Mechanical Designer/Technical Support

DART aerospace Ltd.

Tel: 613-632-5200 Ext. 240
Fax: 613-632-9311
E-mail: mbellavance@dartaero.com
Web: www.dartaero.com

From: Marc Bellavance [mailto:mbellanance@dartaero.com]

Sent: January 8, 2008 11:07 AM

To: 'Fuentes, Roberto'

Subject: D2001

Hi Roberto,

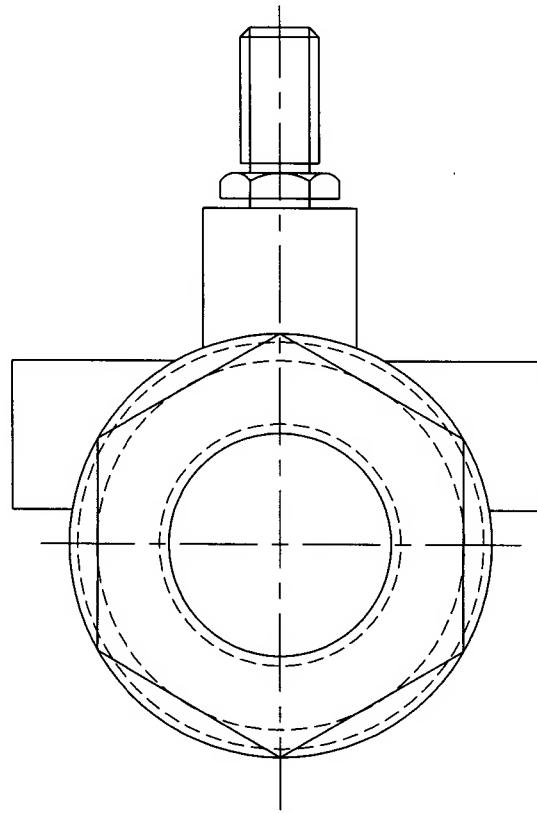
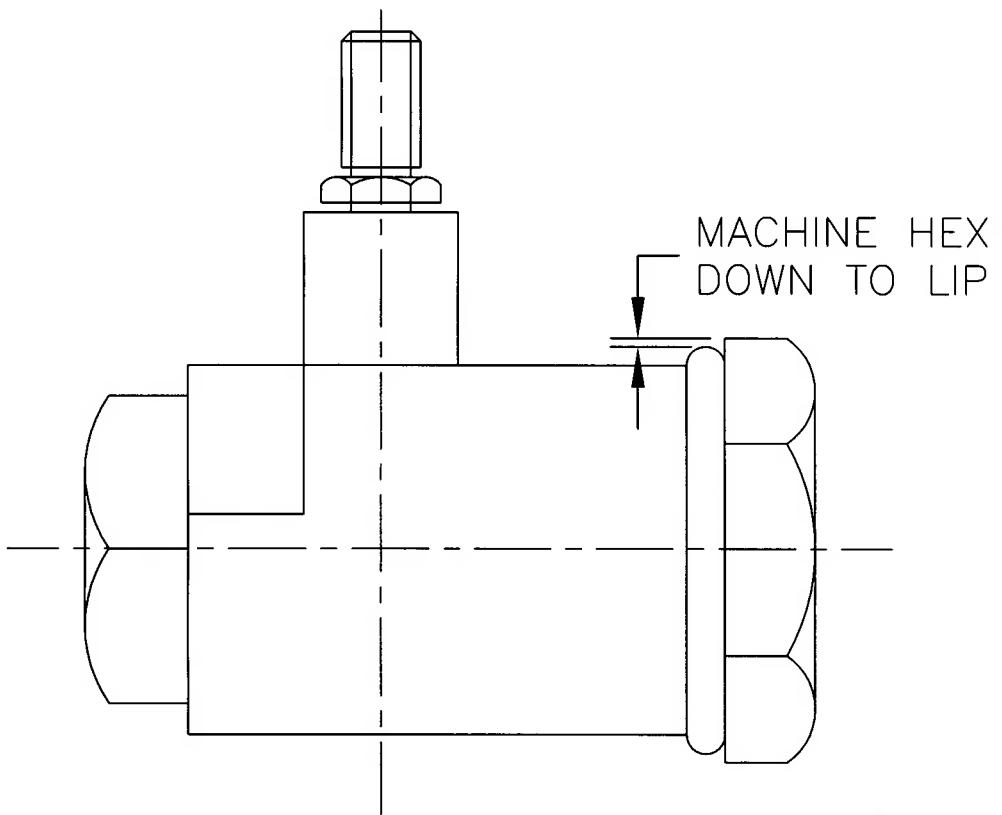
Please take a look at the attached drawing.

QC reported that the orientation of the left hexagonal fitting press fitted into the valve housing is inconsistent. Results, when trying to assemble the valve on the heater, there is some interference. They are asking if the parts would be acceptable if machined down as indicated per the provided sketches. I don't see a problem with that. Do you?

Marc Bellavance
Mechanical Designer/Technical Support

DART aerospace Ltd.

Tel: 613-632-5200 Ext. 240
Fax: 613-632-9311
E-mail: mbellavance@dartaero.com
Web: www.dartaero.com



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WORK ORDER
NO. 36284

